

Date: Wednesday, 9/12/2007 12:16:22 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIGHT ARM PLATE
Job Number : 34634	
Estimate Number : 11875	
P.O. Number : N/A	Part Number : D33545
This Issue : 9/12/2007 S.O. No. : N/A	Drawing Number : D3354 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 30400	Material : N/A
Written By : <u>Kim Johnston</u>	Due Date : 9/21/2007 Qty: <u>5</u> Um: Each
Checked & Approved By : <u>Kim Johnston</u>	
Comment : est rev. A 06.01.14 new issue EC rev B 07.03.023 rev B dwg ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X0200	1010-1025 BAR
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⑧

Comment: Qty.: 0.4148 f(s)/Unit Total : 1.6590 f(s)
1010-1025 BAR

AISI 1010-1025 Steel bar 2.00" x 0.750"

Batch: M105645 Pl 07.09.19

2.0	BAND SAW	BAND SAW
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⑧

Comment: BAND SAW
Cut blanks 4.625" long

Pl 07.09.19

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA612 and Dwg D3353

2- Deburr

SDP 07/12/18 ⑧
SA

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



⑧

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD

SDP 07/12/18

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

OK 07/12/19 ⑧

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/12/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:16:22 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM PLATE

Job Number: 34634

Part Number: D33545

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



WS23



07/12/19

8x

Comment: PACKAGING RESOURCE #1

7.0

QC21

FINAL INSPECTION/W/O RELEASE



8

Comment: FINAL INSPECTION/W/O RELEASE

07/12/20

Job Completion



mi 2007/12/19 CZ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____


QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

2/2/12

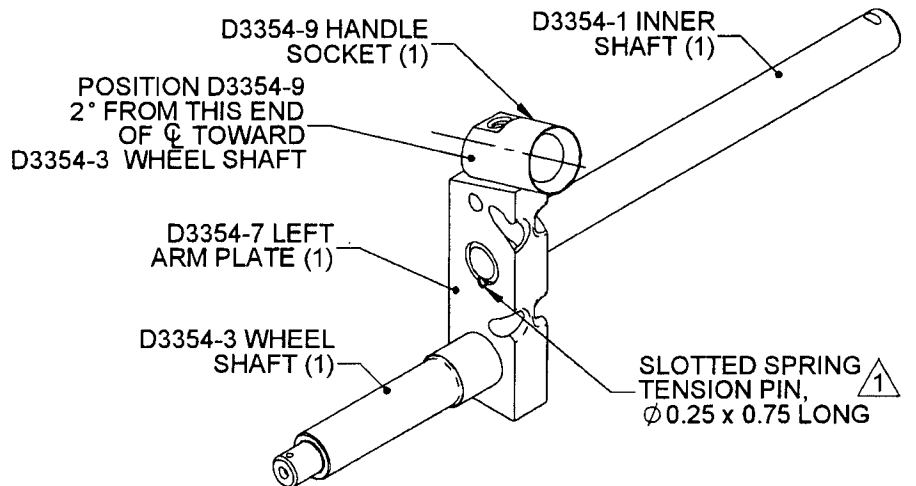
☒ First Article ☐ Prototype

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM	

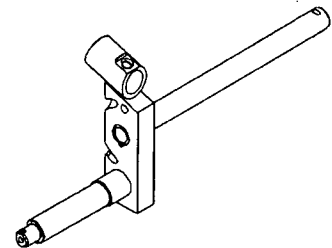


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CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. LEFT ARM WELDMENT	REV. B SHEET 1 OF 7
DATE 07.02.02		TITLE D3354	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	

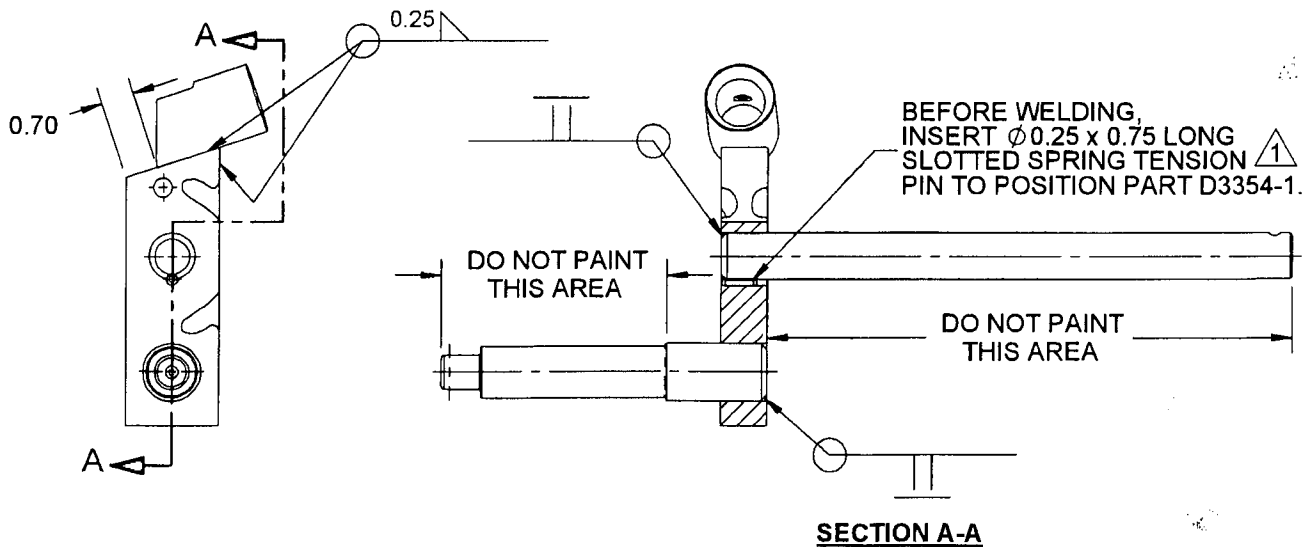
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RF 07.02.02



D3354-041 LEFT ARM WELDMENT



D3354-042 MIRROR ARM WELDMENT



NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAUR, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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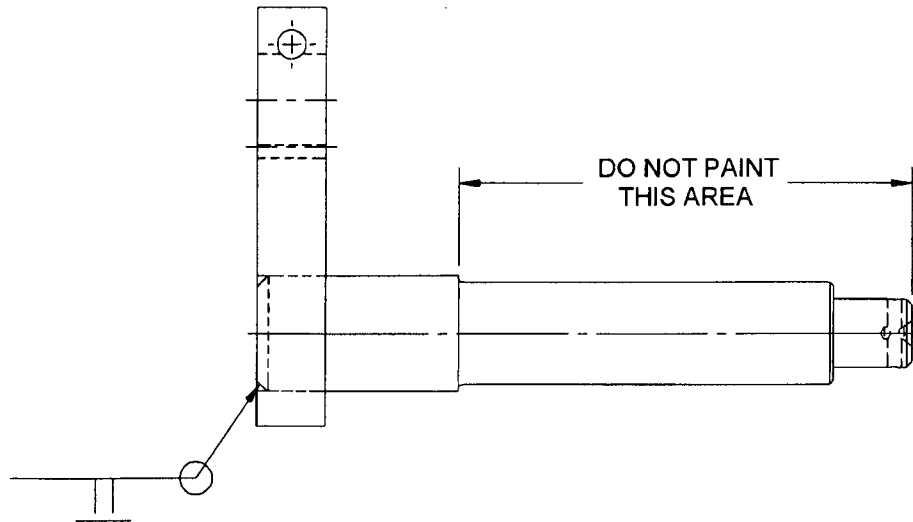
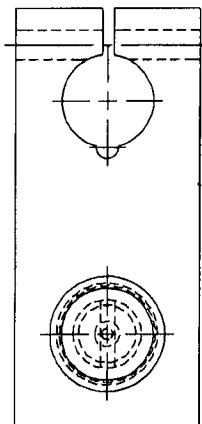
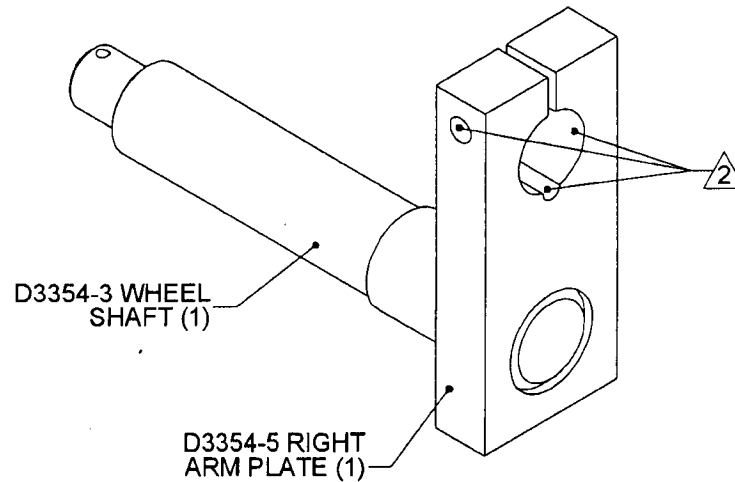
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DATE 07.02.02	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
[Stamp] 07.02.02



D3354-043 RIGHT ARM WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.15
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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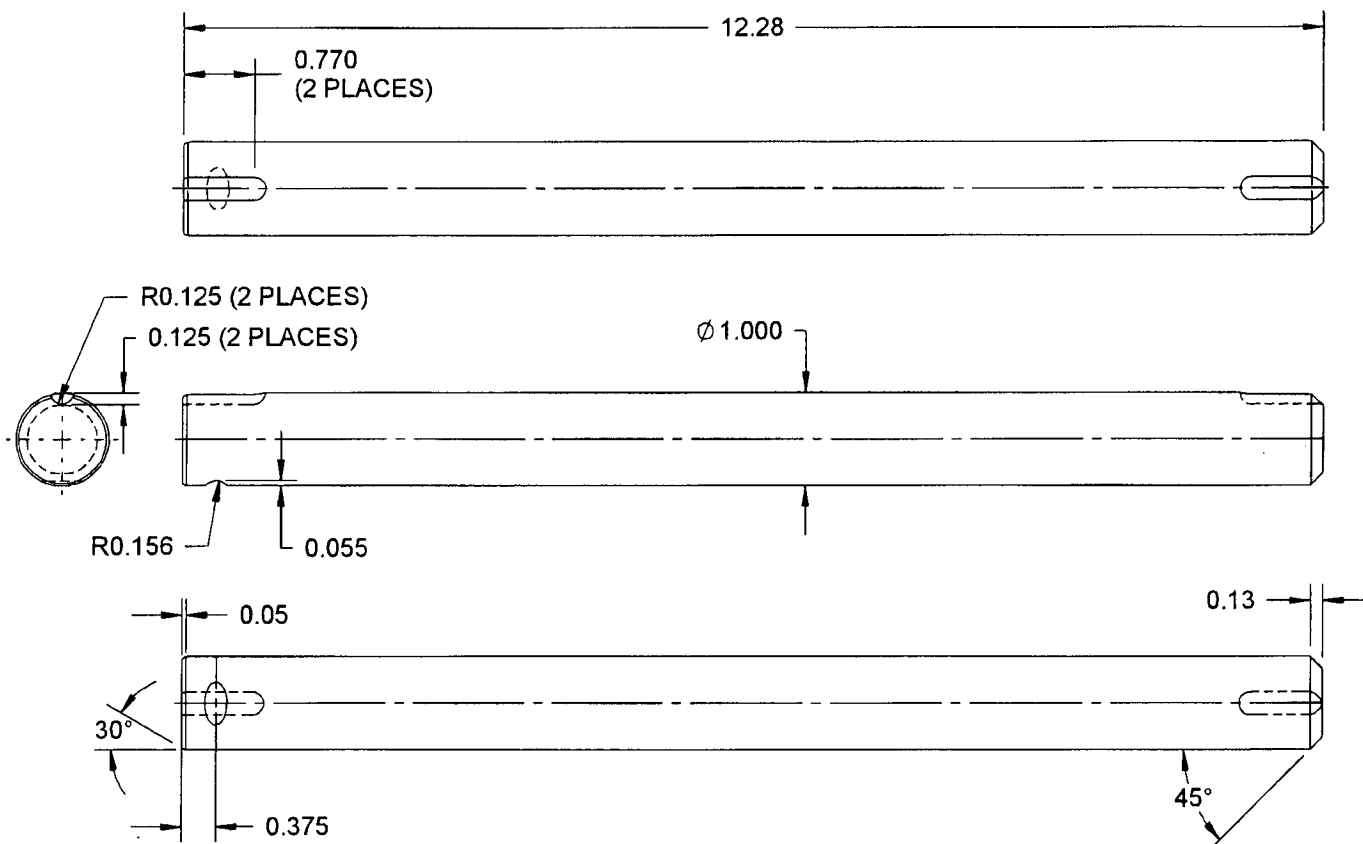
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:2

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[Signature] 07.02.02



D3354-1 INNER SHAFT

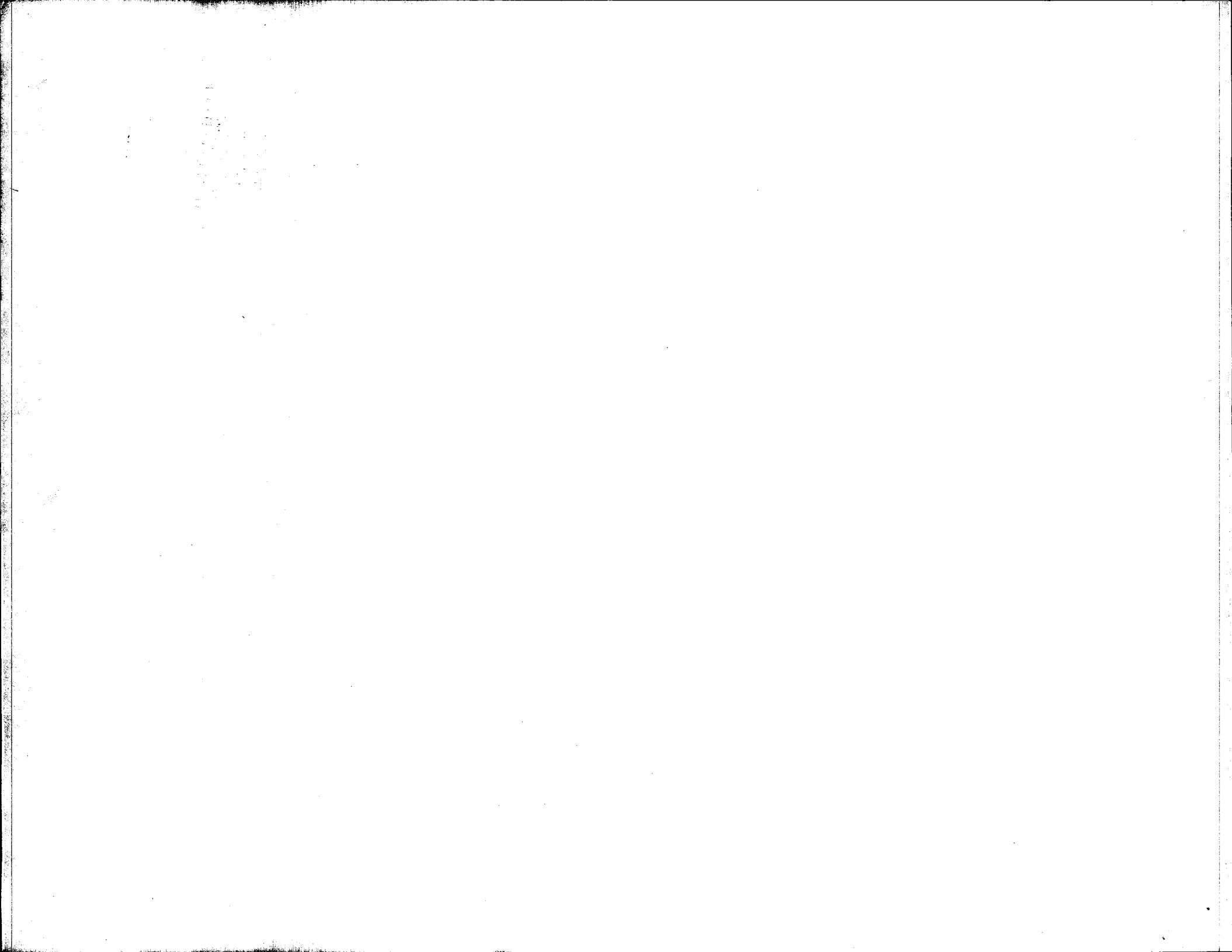
NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS# G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H) CONTROLLED COPY
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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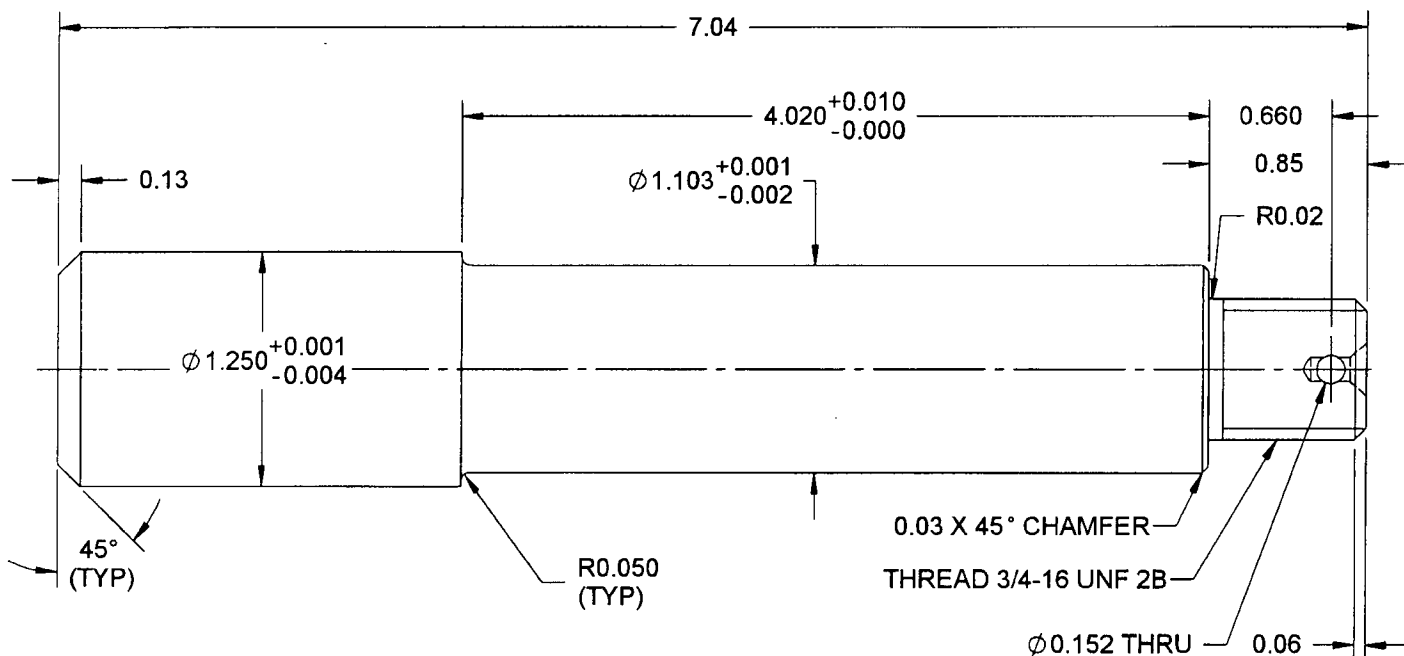
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
[Signature] 07.02.02**D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91
OR UNS# G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R) UNCONTROLLED COPY
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

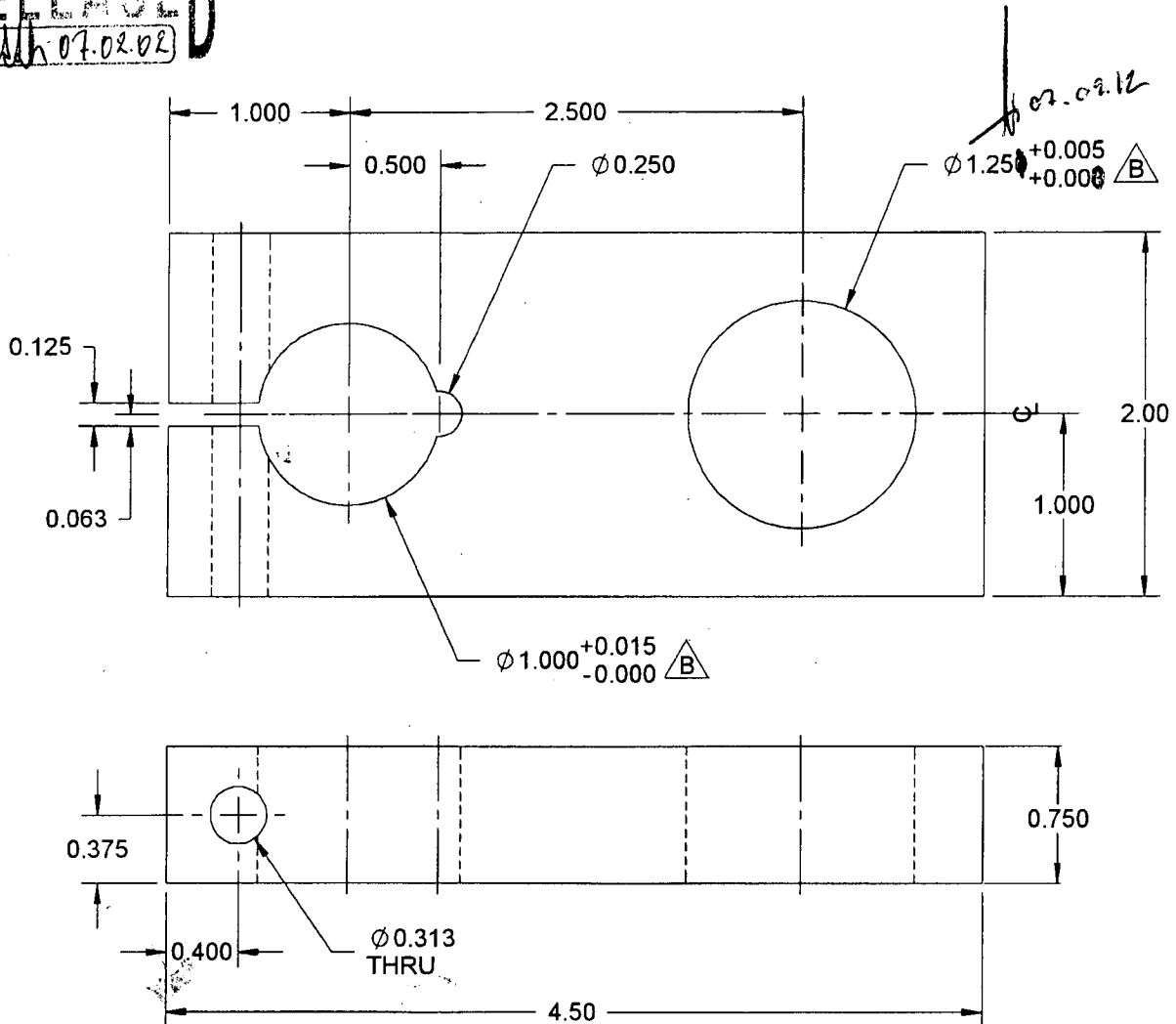
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
07.02.02**D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

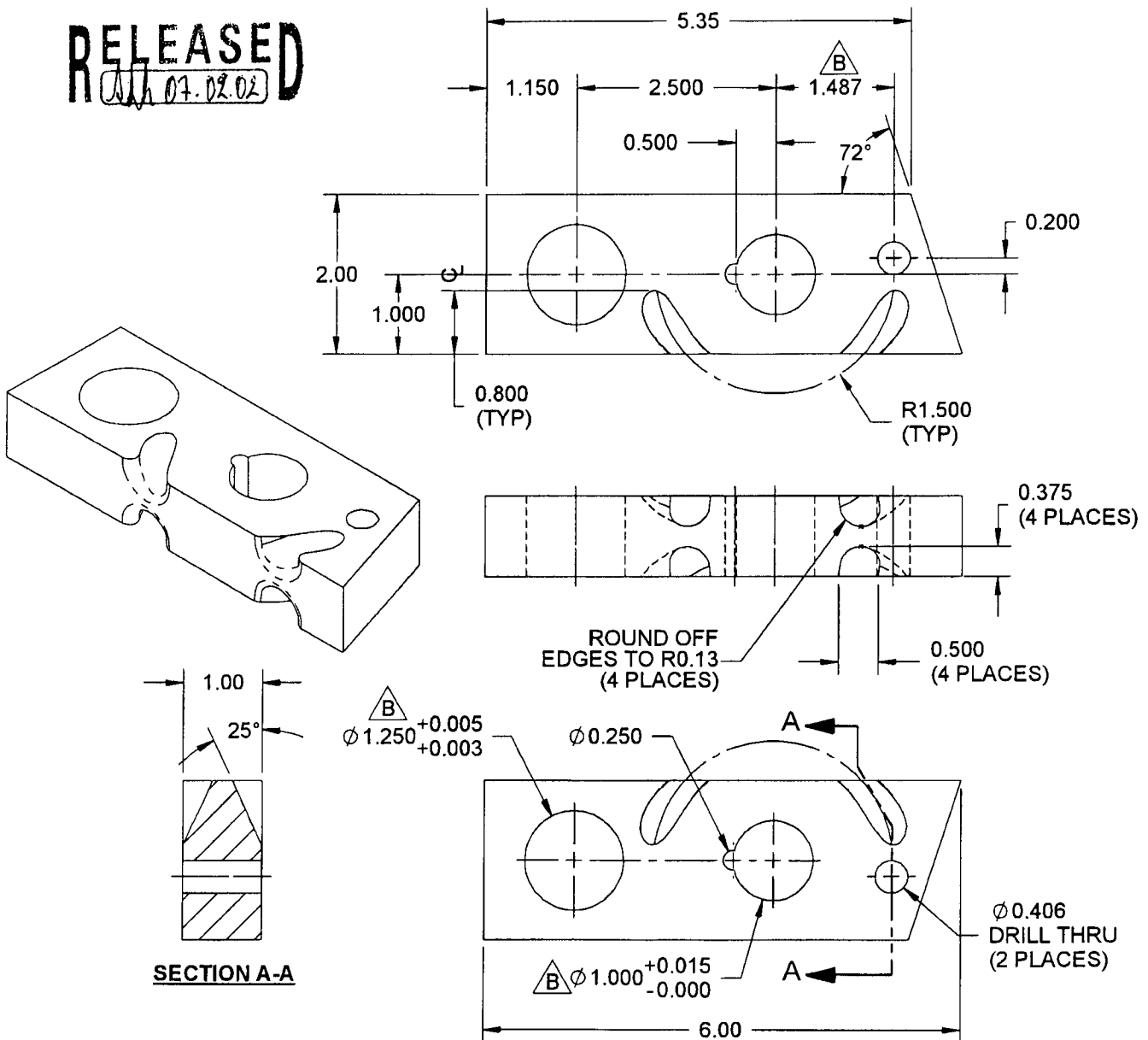
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DATE 07.02.02	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
[Signature] 07.02.02**D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

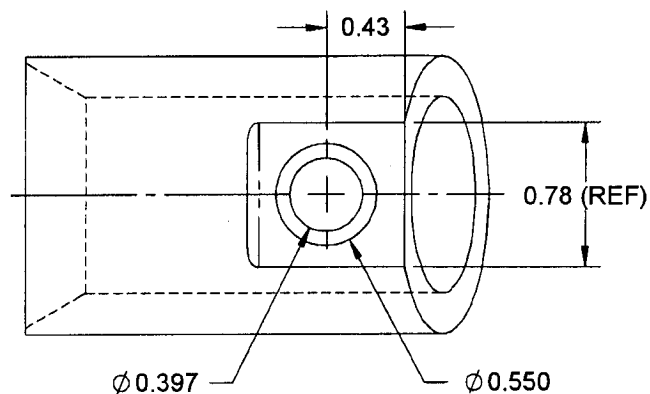
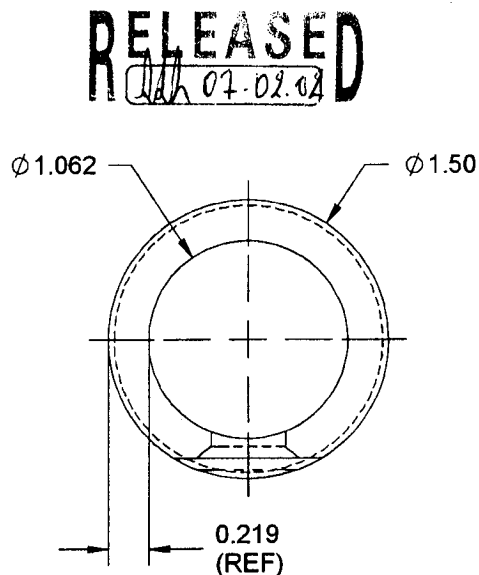
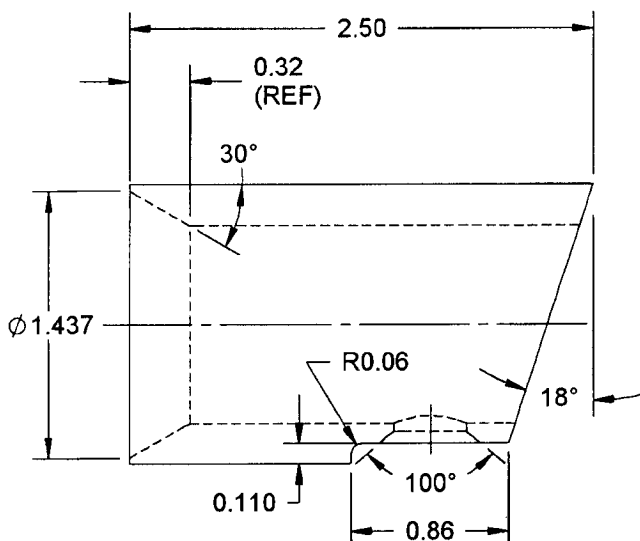
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1



D3354-9 HANDLE SOCKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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